

Date: Tuesday, 5/1/2007 3:17:33 PM
 User: Kim Johnston

Process Sheet

split

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: GROMET
Job Number	: 32127		
Estimate Number	: 12819		
P.O. Number	: <u>NIA</u>	Part Number	: D36191
This Issue	: 5/1/2007	Drawing Number	: D3619 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>NIA</u>	Drawing Revision	: A
Previous Run	: <u>NIA</u>	Material	: <u>NIA</u>
Written By	: <u>[Signature]</u>	Due Date	: 5/8/2007
Checked & Approved By	: <u>[Signature] 07.05.01</u>	Qty:	<u>20</u> Um: Each
Comment	: Est Rev A New Issue 07-04-09 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
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1.0	9610K17	GROMMET
-----	---------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 300.0000 Each(s)
 GROMMET

2.0	PG	PURCHASING
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Comment: Issue P/O: 3678
 Purchase Part Number: 9610K17
 Supplier: MC MASTER CARR
 Certificate of conformity is required

C 207/05/02

300
20

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1
 Receive & Inspect For Transit Damage
 Ensure material certification is attached

Part 7/5 C 7/10/4 (4)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

207/05.07 (4)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1
 Identify and Stock
 Location: _____

207/15/08 (4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 5/1/2007 3:17:33 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: GROMET

Job Number: 32127

Part Number: D36191

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



4

Comment: FINAL INSPECTION/W/O RELEASE

07/05/08

Job Completion



07/05/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

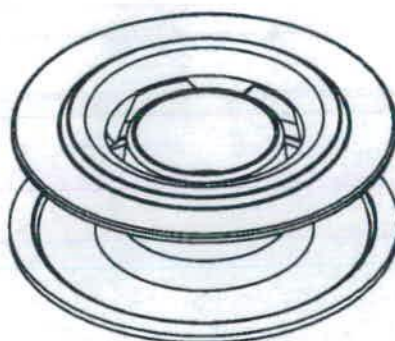
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>LE</i>	DRAWN BY <i>LE</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3619	REV. A SHEET 1 OF 1
DATE 07.03.26		TITLE GROMMET	SCALE NTS
REV A	DATE 07.03.26	DESCRIPTION NEW ISSUE	

SPECIFICATION CONTROL DRAWING



RELEASED
07 04 02 #

D3619-X GROMMET,
WHERE X REPRESENTS THE GROMMET TRADE SIZE

DART P/N	TRADE SIZE	DESCRIPTION	HOLE SIZE	MAX. MTL THICKNESS	MCMaster CARR P/N
D3619-0	0	BRASS GROMMET W/ TEETH	1/4	0.110	9610K16
D3619-1	1	BRASS GROMMET W/ TEETH	9/32	0.120	9610K17
D3619-2	2	BRASS GROMMET W/ TEETH	3/8	0.150	9610K18
D3619-3	3	BRASS GROMMET W/ TEETH	7/16	0.230	9610K19
D3619-4	4	BRASS GROMMET W/ TEETH	1/2	0.300	9610K21

NOTES:

1) PURCHASE INFO: MCMaster-CARR P/N'S INCLUDE THE FOLLOWING:

48 GROMMETS FOR SIZE 0 & 1,
24 GROMMETS FOR SIZE 2, 3 & 4,
D3619-XT1 HOLE PUNCH,
D3619-XT2 STRIKER BLOCK,
D3619-XT3 PUNCH AND
D3619-XT4 DIE

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 32127

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5 DART AEROSPACE LTD
1270 ABERDEEN ST
HAWKESBURY ON
MAIN FINISHED GOODS LOCATION

K6A 1

**YOUR PURCHASE
ORDER NUMBER**

P000003678

Today's Date: 5/02/07

MCMASTER-CARR
200 AURORA INDUSTRIAL PKWY
AURORA OH 44202

IF THERE ARE ANY QUESTIONS ABOUT THIS
SHIPMENT CONTACT OUR SALES DEPARTMENT
(330)995-5500

PAGE

1 OF 1

MCM NUMBE

4000264-0

Warehouse Location	McMaster Carr Part Number	Fill Quantity	Item Description	Your Line	Your Order	This Shipment
2- 41-02 03-22	9610 K17	5 EA	MILITARY SPECIFICATION BRASS GROMMET KIT WITH TEETH, TRADE SIZE 1,48 GROMMETS, 9/32" HOLE SZ 2 Balance of 15 EA expected to ship by 5/8/2007 Information about the rest of your order	1	20 EA	5 4 1 PASSB. 5/10/07
	9610 K18		MILITARY SPECIFICATION BRASS GROMMET KIT Balance of 20 EA expected to ship by 5/8/2007	2	20 EA	721

